

Work Order ID **94095**

**\*94095\***

Page 1

November-30-12 9:00:55 AM

Item ID: **D3950-1**

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: RIVET

Start Date: 11/30/12

Start Qty: 6000

**\*60\***

Cust Item ID:

Required Date: 12/14/12

Req'd Qty: 6000

**\*60\***

Customer:

Reference:

Approvals:

Process Plan: **MLJ**

Date: **12-12-03**

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3950	REV A
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100		0.00
-----	--	------

**\*100\***

Purchasing

Memo

0.00

Purchasing

Issue P/O: **18587**  
Purchase Part Number: PR-71  
Supplier: SPAENAU  
Certificate of conformity is required

**12-5-12**  
**50**

110	Receive & Inspect for Damage & Mat'l Certs	0.00
-----	--------------------------------------------	------

**\*110\***

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

**12/12/10** **(500)**

120	QC6- Inspect dimensions to drawing	0.00
-----	------------------------------------	------

**\*120\***

QC

Memo

0.00

Quality Control

**DAS**  
**15**  
**12/12/12**

**DAS**  
**16**  
**12/12/12**

**500**

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	<b>Date</b>	<b>Step</b>	<b>Qty</b>	<b>Description of work order update or Non-conformance</b>	<b>Initial Chief Eng</b>	<b>Action Description</b>	<b>Sign &amp; Date</b>	<b>Verification</b>	<b>QC Inspector</b>		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other	

# Picklist Print

November-30-12 9:00:54 AM

Page 1

Work Order ID: 94095

Parent Item: ~~D3950-1~~

Parent Item Name: RIVET

Start Date: 11/30/12

Required Date: 12/14/12

Start Qty: 60.00

Required Qty: 60.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<del>20-71</del> <del>Rivet</del>		Purchased	No				Each	0.0000		60		11/30/12	60.00

NCR: Yes / No

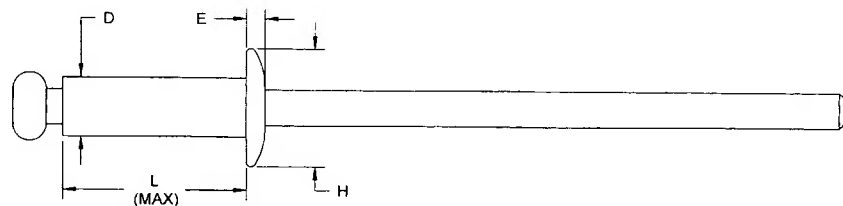
**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
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# SPECIFICATION CONTROL DRAWING



SHOWN  
RELATIVE  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO  
WITH  
NO. 94095 MLJ  
12-12-03



## D3950-X RIVET

DART PART NUMBER	DESCRIPTION	SUPPLIER	SUPPLIER PART NUMBER	MANUFACTURER NUMBER	RIVET BODY DIAMETER "D"	HOLE SIZE AND DRILL NUMBER	GRIP RANGE	LENGTH UNDER HEAD "L"	HEAD DIAMETER "H"	HEAD HEIGHT "E"
D3950-1	RIVET - 5056 ALUMINUM BODY WITH COATED CARBON STEEL MANDREL	SPAENAU	PR-71	AD44BS	0.125	0.129 - 0.133 #30	0.188 - 0.250	0.390	0.250	0.040

RELEASED  
2009-08-28  
MB

- NOTES:
- 1) MATERIAL: SEE TABLE
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A

A	NEW ISSUE	09.06.05
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.06.05	

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3950** REV. A  
SHEET 1 OF 1

TITLE **RIVET** SCALE NTS

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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO18587

Purchase Order Date 12/05/12

PO Print Date 12/07/12

Page Number 1 of 2

Order From :

VC-HAS001

HASKINS INDUSTRIAL  
5-52 ANTARES DRIVE  
NEPEAN, ON K2E 7Z1  
CA

Contact Name

Vendor Phone 613 723 8800

Vendor Fax 613 723 8806

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Brigitte Golden

10127-2607

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

REVISED \$

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1		R510 14.25MM Drill	12/10/12 Yes	4.00 Each	Dicom	\$345.2600	\$1,381.04
2	PR-71	Rivet	12/10/12 Yes	500.00 Each	Dicom	\$0.0294	\$14.70
3		OFPT06L5AFENGB KC825M INSERT	12/10/12 Yes	30.00 Each	Dicom	\$11.0200	\$330.60
4		SGS-36517 END-MIL 1/2	12/10/12 Yes	4.00 Each	Dicom	\$52.1500	\$208.60

Deliver To: JL

Special Inst: As per DWG: D3950 Rev:A  
B94095

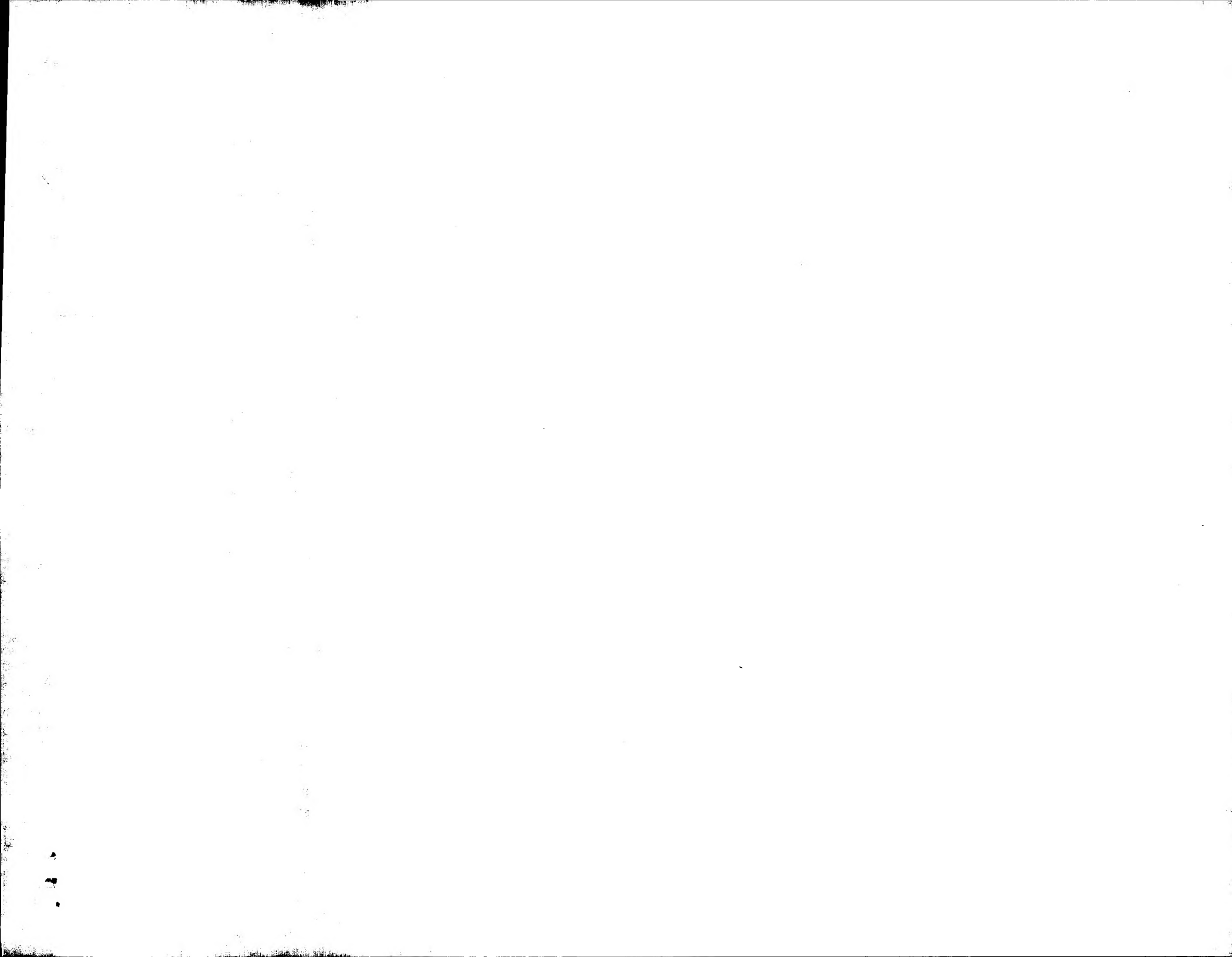
Deliver To: CNC

Deliver To: CNC

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required - YES NO

Change Nbr: 4

Change Date: 12/07/12



MASKINS INDUSTRIAL INC.  
5-52 ANTARES DRIVE

\*\* PACKING SLIP \*\*

Order # 1247358.00

Order Date 12/06/12

Page 1 of 1

NEPEAN, ONTARIO K2E 7Z1  
TEL (613)723-8800 FAX (613)723-8806

\* Reprint \*

Sold To: DART AEROSPACE LTD.  
1270 ABERDEEN STREET  
HAWKESBURY  
ON  
K6A 1K7

Ship To: DART AEROSPACE LTD.  
1270 ABERDEEN STREET  
HAWKESBURY  
ON  
K6A 1K7

Cust Phone #	Warehouse OTTAWA	F.O.B. DEST	Taken By Sylvie 613-723-880
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Cust #	Customer P/O #	Required	Orig Order	Slsm	Ship Via	Terms
05168	18587	12/07/12	1247358.00	PL	DICOM	NET 30

Ln#	Bin #	Order UM	Ship	B/O Product	Description
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1		4 EA	4 ✓	PTD1X1 0115640	R510 14.25MM DRILL
2		500 C	500 ✓	SP1X100	PR-71 RIVET
3		30 EA	30 ✓	KEO1X1 2453684	OFPT53AFEN4GB KC725M INSERT
4		4 EA	0	4 SGS1X1	36517 1/2" Z16CR CARB EM
5	CB1185	5 EA	5 ✓	PTD-0572085	A012 31/64 JOBBER DRILL TIN (5)
6	*	3 EA	3 ✓	SO1X1	604-086 #26060 PITBULL CLAMP 6/PKG
7		3 EA	0	3 1X1	D675-KIT REBUILD KIT FOR VISE

PLEASE NOTE:

1. NO RETURNS WITHOUT PRIOR AUTHORIZATION
2. ALL SHORTAGE CLAIMS MUST BE WITHIN 10 DAYS
3. BO CODE: BO = QTY NOT SHIPPED IS BACK-ORDERED  
CL= QTY NOT SHIPPED WAS CANCELLED  
SC= ITEM CONSIDERED COMPLETE - NO B/O CREATED

FILL 9 PACK 8 DATE 12 17 12  
Printed on 2012-12-07 at 9:33